

542

| | | |
|---------------------------|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 24613 |
| Description: Plate | Part Number: | D3163-1 |
| Dwg: D3163 Rev. B | Qty: | 6 |
| | | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty |
|------|-----------------------|--|-----|----------|-----|
| 1 | DC | Issue Traveler | KJ | 05.10.18 | 6 |
| 2 | PG | Issue P/O: <u>2008644</u> Email or Ship DXF file to vendor Laser Cut D3163-1 flat pattern per Dwg D3163 Possible Supplier: GFI Material release note is required | LL | 05-10-18 | 6 |
| 3 | RG | Receive and Inspect for transit damage Enure material release note is attached | CL | 05/10/18 | 6 |
| 4 | QC6 | Inspect dimensions as per Dwg D3163 | ml | 05/10/19 | 6 |
| 5 | CA | Deburr | ml | 05/10/19 | 6 |
| 6 | FP | Chemical Conversion Coat per QSI 005 4.1 | FC | 05/10/24 | 6 |
| 7 | EP | Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI.005 4.3 | | | |
| 8 | QC3 QC3 | Inspect Powder Coat Inspect Conversion Coat | KJ | 05-10-25 | 6 |
| 9 | ST | Identify and Stock <u>IN SPACEDOR Room</u> | ml | 05-10-25 | 6 |
| 10 | AC | Cost / part: <u>45.27</u> | SUR | 05-10-27 | 6 |
| 11 | DC | Close W/O <u>45.27</u> Inspect Level 21 | SP | 05/10/27 | 6 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.09.27 | New issue | KJ/RF | KJ |

RELEASED
 05.10.03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/10/27

NOTE: Date & initial all entries

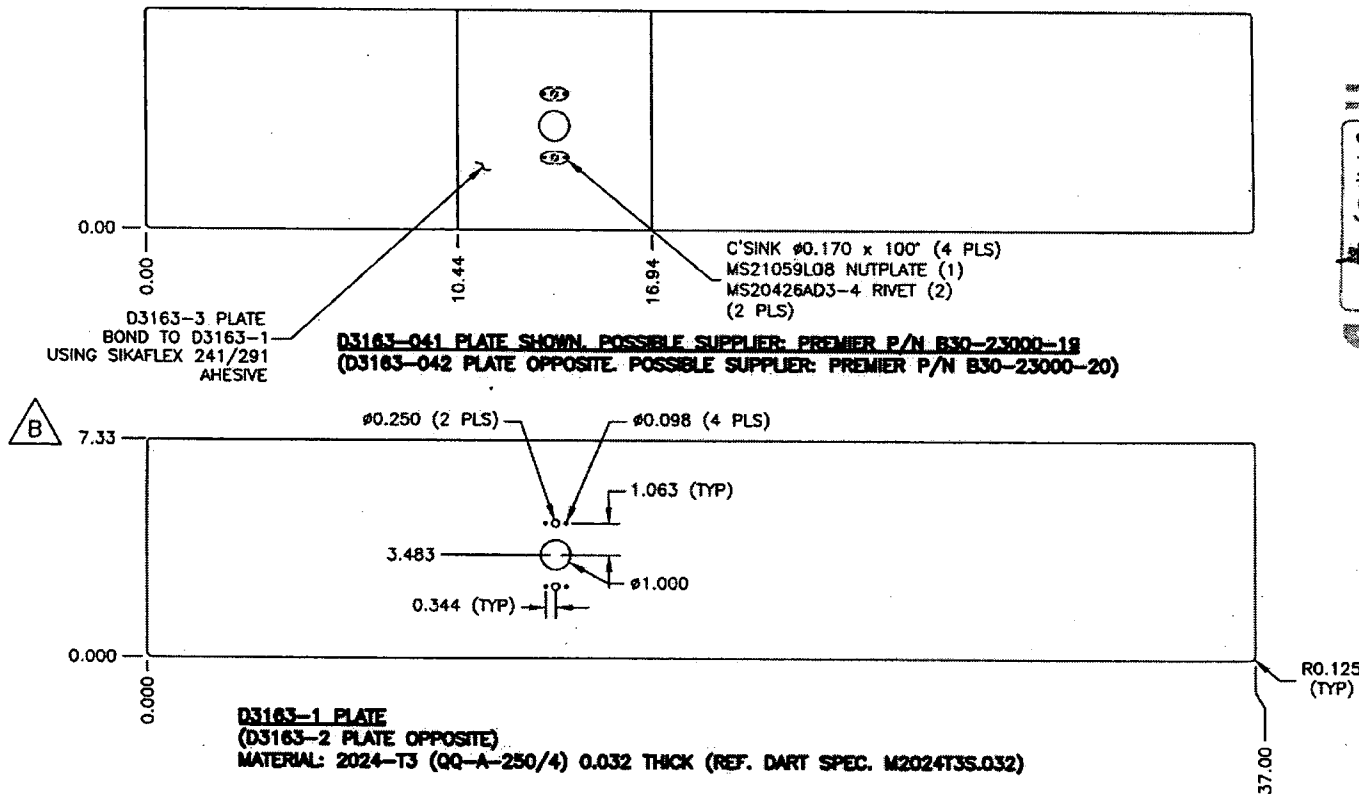
QA: N/C Closed: _____ Date: _____

QA COPY ISSUED

HAWKESBURY, ONTARIO, CANADA

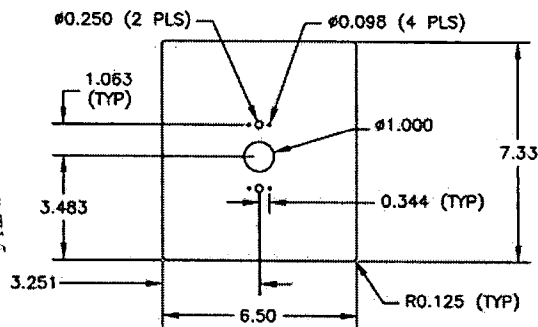
| | | | | |
|----------|----------|---------------------------------------|-------|--------------|
| DESIGN | DART | DART AEROSPACE LTD | | REV. B |
| DRAWN BY | 1-25 | HAMKESBURY, ONTARIO, CANADA | | |
| CHECKED | 11 | APPROVED | 11 | |
| DATE | 04.10.06 | TITLE | D3163 | SHEET 1 OF 1 |
| | | SCALE | 1:6 | |
| A | 02.04.26 | NEW ISSUE | | |
| B | 04.10.06 | 7.33 WAS 7.20; REMOVE PERIMETER HOLES | | |

04.11.23



D3163-1 PLATE
(D3163-2 PLATE OPPOSITE)

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032)



D3163-3 PLATE

MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)

GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 19, 2005
07:44 am

Work Order No : 0024613
Project Name : D3163-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3163-1
Description : Plate
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-19-05
Est Finish Date : 10-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | | |
|--------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

| | | | | | | |
|-------------------------|----------|----------------|-------------|---------------|---------|-----------|
| CERTIFICATE NO. | 1 | OUR JOB NO | J0133194 | SHIPPING MEMO | 0320240 | |
| ITEM | QUANTITY | PURCHASE ORDER | PART NUMBER | REV | NAME | DWG ISSUE |
| - | 6 PCS | 2008644 | D3163-1 | B | PLATE | B |
| MATERIAL | | SUPPLIED BY | | MAT. REL. NO. | | |
| AL 2024-T3 (QQ-A-250/4) | | ALCOA INC | | 521271ATT'D | | |

| | PROCESS | PROCESSOR | RELEASE NOTE # |
|---|---------|-----------|----------------|
| 1 | | | |
| 2 | | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 | | | |
| 7 | | | |
| 8 | | | |
| 9 | | | |

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 11 OCTOBER 2005

G.F.I. Q.C. REP. *Dutton H. St*



C e r t i f i c a t e d e C o n f o r m i t e

Vendu Par:

ATLAS/IDEAL METALS

3399 FRANCIS HUGHES

LAVAL

QC H7L 5A5

GST/TPS REG. # 142997238

QST/TVQ REG. # 1022412252

Tel: 514-385-0111 Teloc: 514-385-2330

P/O No: 31904

Rel :

S/O No: 256773.1

B/L No:

Inv No:

Vendu A: (124490)

G F I INC. ***

180 AVE LABROSSE

POINTE CLAIRE

Tel: 1514630-4877

Teloc: 514-630-4849

Livre V: (1)

G F I INC. ***

180 AVE LABROSSE

POINTE CLAIRE

H9R 1A1

QC H9R 1A1

QC

C e r t i f i c a t d e C o n f o r m i t e

Cert. No: 21038

Code: 54181904

AL SHT TL QQA250/4 2024T3 BARE

.032 X 48 X 144

Mcx
2

Poids
45

P.O.# - 21478

Numero de Lot
521271

Test ID
LN-4391

Numero de Controle
29C05321

2

45

***** Analyse Chimique *****

CECI N'EST QU'UN CERTIFICAT DE CONFORMITE

A QUI DE DROIT,

LA PRESENTE EST POUR CERTIFIER QUE LA MATERIEL
FOURNI CI-HAUT EST CONFORME AUX SPECIFICATIONS
INDIQUEES SUR VOTRE COMMANDE CI-HAUT MENTIONNEE.

Claudia Claude
SIGNATURE AUTORISEE

INVOICE TO SHIP TO

CERTIFIED INSPECTION REPORT

IDEAL METALS & ALLOYS LTD.,
268 ORENDA ROAD,
BRAMPTON, ONTARIO, CANADA
L6T 4A9
CANADA,

IDEAL METALS & ALLOYS LTD.,
268 ORENDA ROAD,
BRAMPTON, ON L6T 4A9

98-072

ALUMINUM COMPANY OF AMERICA

21478

CUSTOMER () 10./GOVT CONTRACT NO.

PITTSBURGH, PA.

SHIPPED FROM: K

PAGE

We hereby certify that the material covered by this certificate has been inspected in accordance with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet. Per

Invoice No. 22504342 Invoice Date 99/01/07 Code 667 434710

ALCOA No. ICO57835 Ship Date 99/01/07 VIA FREDERICK TRANSPORT

Michael J. Skoglund Quality Assurance Manager

Product Description SHEET

B/L No. 8557 Gross Weight 4530

Alloy-Temper 2024 T3

ITEM DESCRIPTION

Quantity Shipped

of Tests & Dir

Test² Test² Test² Test² Test² Test² Test²

ITEM 2
.032 IN TK X 48.000 IN W CAT D
164132 (N) A/T 2024-T3 COILED
SHEET MILL FINISH. PER
AMS-QQ-A-250/4 PER AMS4037 REV M
PER ASTM209 REV 96
((NOT MARKED)) LIGHTLY OILED
COIL SIZES: ID 20 IN COIL WGTS:
MAX 5625 LB SKID WGT: 6000 LB
QUAN TOL +/-10 %
CQR D164132 REV 09
CUST REQ 98-12-31

PCS., FT., ETC. Pounds
4417
LOT-521271 T3
1PC

2 L.T

MAX 69.8 48.1 16.5
MIN 69.3 47.1 16.0

SI FE CU MN MG CR ZN TI
.07 .17 4.59 .62 1.54 .01 .09 .03

Cast analysis from a representative sample during the casting process

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF
AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E,
AMENDMENT 2. PRODUCT PRODUCED AND MARKED TO THE REQUIRE-
MENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE
REQUIREMENTS OF AMS-QQ-A-250/4.

Pkg-No Lot-No Wgt Pc
788766 521271 4417 1

Chemical Composition SI FE CU MN MG CR ZN TI OTHER OTHER ALUMINUM
.50 .50 4.9 .9 1.8 .10 .25 .15 .05 .15 REMAINDER
2024 Min. 3.8 .30 1.2 EACH TOTAL

Alloy Min.

Chemical Composition

Min.

CT 18 '00 10:12PM IDEAL METALS

P.C